Work	Ord	er ID	103	3072

103072

Page 1

Jüne-12-13 9:2	26:27 AM										
Item ID:	D3200-1			Accept	*N900	0401	იი*	Setup	Start	*N:	S1*
Revision ID: Item Name:	Door Post Blo	ock		*					Stop	*N:	S2*
Start Date:	6/11/13	Start Qty: 16.00	*16*		Cust Item 1	D:					
Required Date		Req'd Qty: 16.00	*16*		Customer:						
Reference:			1 ()								
Approvals:	Process Pla	an:	Date: 3-01-17	Tooling:	D	ate:		Run	Start Stop	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:			Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description	,	Set Up/ Run Hours	Tool ID	Tool # P	lan Acc			Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr									
D3200	Re	v A		•							
100				0.00	11/1	/ ,		1			5
100		BAND SAW			MM 13	1061	73-	<u> </u>	L)	
Bandsaw		Memo	2 7001 2 700	0.00		′ /	-		U		
Jeaspa Bandsaw		Cut blank:	2.700" x 2.700								
(a)											
110		HAAS CNC VERTICA		0.00	DR./b.a	13/02/	, —	•	1		* 2
**110*		HAAS CNC VERTICA	L MACHINING #1	0.00	DK . 125.12	13/07/	/	<u> </u>	<i>[</i> 5	,	
HAAS 1	. 1: //1	Memo	D3200-1 as per Folio FA33		ehurr			/			
HAAS CNC verti	cal machine #1	1-Machine	D3200-1 as per rono 1733	7 and Dwg D32002-D	Court						-
					ı						
120		QC2- Inspect parts off r	nachine FAI/FAIB	0.00	De/Ba	13/07	115				
120		(F F			12.13.0	•					
QC		Memo		0.00							
Quality Control											

DQA: _			Date:				AART						
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA		ork Order up	date only	AEROSPACE
Morle Orde						DISPOSITION			Д		PARTMENT/		
Work Orde	er. —					D					1		,
Part N	lo.					Rework Scrap			—	rosstube mall Fab	Dwa	Water Jet	Engineering
raiti	···		· · · · · ·			Use-as-is			· · · · · · · · · · · · · · · · · · ·	Finishing	1	d. Eng. Coor. e/Packaging	Quality Other
NCR N	No.					Suspected Unapproved		THEIT	~ 	mposite	1 100	Supplier	
							1		Edige 105	///posite	J	Supplier [
Root					Desci	ription of work order update	1	nitial	Action		Sign &		
Cause	D	ate	Step	Qty		or non-conformance	Ch	ief Eng	Descriptio	on	Date	Verification	QC Inspector
Design								\					•
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup					•								
Process													
Supplier													
Training													
Transport													
Unapproved													
							FAI	JLT CAT	TEGORY		<u> </u>		
Landir	ng Gear					General							· · · · · · · · · · · · · · · · · · ·
	Ben	ding				Bend		Folio/P	Program		Outside Dim	ensions	Pressure/Forced
	Cen	tre Not	t Concen	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Crad	ks				Broken/Damage/Defect		Hardwa	ire		Part Incorrec	t 🗍	Temperature/Cure
	Crin	np/Kinl	k/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Unquali	lified	Part Lost/Mis	ssing	Weld
	Cuff	s				Contamination		Instruct	ions Incomplete/Unclea	ar	Part Moved		Wrong Stock Pulled
	Crus	hing				Countersink		Misalig	ned/off center		Positioned W		
	Hea	t Treat	:			Cut Too Short		Mislabe	eled		Power Loss/S	Surge	Other
	Insp	ection	Strip in	Tube		Drawing		Misread	d		•	-	•
	Mar	ks/Cha	atter			Drill Holes		Off-set					
	Turr	ning Se	quence			Finish		Out of (Calibration				-
	<u>}</u>			Fit/Function		Out of 9	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

103072

Page 2

lune-12-13 9:2	26:27 AM	<u> </u>								
item ID: Revision ID:	D3200-1		A	Accept	*N900	04010	n* s	etup Start	ı u.	S1*
Item Name:	Door Post Blo	ock						Stop	*N:	S2*
Start Date: Required Date	6/11/13 e: 6/11/13	Start Qty: 16.00 Req'd Qty: 16.00	*16* *16*		Cust Item I Customer:	D:				
Reference:		1 20	173							
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:	F	Run Start	1/1	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:		Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		QC8- Inspect parts - seco	nd check	0.00			17			
130 QC Quality Control		Мето		0.00	0]6	<u>Ø</u> _		
140 * 4 4 0 *		Identify as per dwg & Sto	ock Location: <u>5T033</u>	0.00			Vare		M ill	1 12 07 V
140 Packaging Packaging		Memo		0.00		·	_IQX		1 . 2	. <u>13-</u> 07-16
150		QC21- Final Inspection -	Work Order Release	0.00				1-7	1-/1	7 D
150 QC Quality Control		Memo		0.00					1 <u>///</u> /}	1-10) NF 13-7-16
										13-11

DQA:			Date:			- ·	TARPI						
QA Closed:			Date:			WORK ORDER NON	I-C	ONFO	RMANCE / UPDATE	14/	ork Order uj	ndate only	AEROSPACE
QA Closed.			Date.					,		VV	ork Order u	date only	
Work Ord	er:					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
	•					Rework	7		Skid-tube Crosstub	e	7	Water Jet	Engineering
Part	No.					Scrap	1	``	Machining Small Fab Prod. Eng. Coor.				Quality
	•					Use-as-is]	Thermoforming Finishing Rec/Store/Packaging			Other		
NCR	No.					Suspected Unapproved]	Large Fab Composite Supplier			Supplier		
Root					Desc	ription of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance		hief Eng	Description		Date	Verification	QC Inspector
Design							1						
Doc/Data													
Equip/Tooling							1						
Handling/Pre													
Material													
Operator								A					
Offset/Setup								*,					
Process												·	
Supplier								•					
Training													
Transport											:		
Unapproved	\prod					•							
				,			FA	ULT CA	TEGORY				
Land	ing (Gear				General		,					
:		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect				ssing	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misaligned/off center -			Positioned V	Vrong	
	L	Heat Trea	at			Cut Too Short		Mislabe	eled	Г	Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing	.[_	Misread	d ·				•
		Marks/Ch	natter			Drill Holes		Off-set	7 Park				
		Turning S	Sequence			Finish		Out of	Calibration	•	•		
		Wave/Tw	vist in Tuh	ne		Teit/Function		Out of	Seguence		· · · · · · · · · · · · · · · · · · ·		

June-12-13 9:26:26 AM

Work Order ID:

103072

Parent Item:

D3200-1

Parent Item Name:

Door Post Block

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 16.00

Required Qty: 16.00

IPP Rev:A Removed from 9 Digit 06-01-25 JLM

	placement m ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	815.0950	0.05	0.842105	6		

Location	Loc Qty	Loc Code		
MAT019	815.0949895		· · · · · · · · · · · · · · · · · · ·	20M13110-
121278	12.0949895		.8421	W413/0E/23
122575	47.6			
123229	53			
123704	63.8			
123949	6.96			
124382	197.12	¢		
124758	34.52			
125137	400			

DQA:			Date:			_								THE STREET	TO A C
						WORK ORDER NON	-C	ONFO	RMANCE / I	UPDATE			_		AEROSPACE
QA Closed:			Date:					·			W	ork Order up	odate only	丄	
Work Ord	er:					DISPOSITION			÷	AGAINST	DE	PARTMENT	/PROCESS		
	•	·				Rework	1		Skid-tube	Crosstube	. [1	Water Jet	\neg	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	-	Pro	d. Eng. Coor.	\neg	Quality
Ì	•	······································				Use-as-is	1		Thermoforming Finishing Rec/Store/Packaging			一	Other		
NCR I	No.					Suspected Unapproved	1		Large Fab	Composite		1	Supplier	\dashv	
									· —	•	_	_			
Root		i			Desc	ription of work order update		Initial	Α	ction		Sign &		П	
Cause	_	Date	Step	Qty		or non-conformance	Ct	nief Eng	Des	cription		Date	Verification	1	QC Inspector
Design	Ш														
Doc/Data	Щ						}		1						
Equip/Tooling									1			:			
Handling/Pre	Ш				İ										
Material															
Operator	Ш														
Offset/Setup	Н														
Process	\vdash														
Supplier	Н														
Training	\vdash														
Transport	Н													-	
Unapproved			ł		<u> </u>				[1	<u> </u>		
Landi	na G	Coor					FA	ULI CA	regory						
Lanui		Bending				General Bend		ادمانه رد	rogram			Outside Dim	: Г	\neg	0
	\vdash	Centre No	nt Concer	ntric	-	BOM/Route	-	Grain	Togram		\vdash	-	-		Pressure/Forced
		Cracks	ot concer	itile .	⊢	Broken/Damage/Defect	-	Hardwa	uro.		\vdash	Over/Under Part Incorred	 	_	Set-up Temperature/Cure
	Н	Crimp/Kir	nk/Rinnle	/Wave		Burrs	\vdash	-{	ion Incomplete/	Unqualified	\vdash	Part Lost/Mi	-		Weld
		Cuffs	ту трріс	, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	-	Contamination	\vdash	┥ `	ions Incomplete	·	\vdash	Part Moved	221118	_	Wrong Stock Pulled
	\vdash	Crushing				Countersink	\vdash	4	ned/off center			Positioned V	Vrong L	'	wrong stock runed
	\vdash	Heat Trea				Cut Too Short	\vdash	Mislabe			\vdash	Power Loss/		\neg	Other
	\vdash	Inspectio		Tube	-	Drawing	\vdash	Misread			<u></u>	7. OMEL 1033/	Juige	т,	Ottiei
	$\overline{}$	Marks/Ch				Drill Holes	\vdash	Off-set							
	П	Turning S				Finish	\vdash	┥	Calibration						7
		Wave/Tw				Fit/Function		-	Sequence						· · · · · · · · · · · · · · · · · · ·

DART AEROSPACE LTD	Work Order:	103072
Description: Door Post Block	Part Number:	D3200-1
Inspection Dwg: D3200 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005 -0.000	.196			DR 05	6" UERD
0.405 x 100°	+/-0.010	.412			DR 05	6"VEZN
R0.100	+/-0.010	.100	1		1	GAUGE.
R0.130	+/-0.010	,125			1	S Chuat -
1.630	+/-0.005	1.631			DROS	6"UERN
0.440	+/-0.030	.445			DROS	G"VEZN.
2.500	+/-0.010	2.505			DR05	6"VERN
1.845	+/-0.010	1.850			HIEGHT	į.
0.015 - 0.050	N/A	.035			DROS	
1.000	+/-0.010	1.00			DROT	6" yern.
1.620	+/-0.005	1.621			DRUS	6" usen.
2.500	+/-0.030	2.500			DROS	6" VERN.
0.750	+/-0.030	.745			DEOS	G' VERN.
			·			

	1					

		$\triangle AS$		
Measured by: 12 / 12 A	Audited by:	40	Prototype Approval:	N/A
Date: 13/07/15	Date:	13/07/15	Date:	N/A

Rev	Date	Change		Revis	ed by	Approved
Α	03.11.12	New Issue	P/O D412-698-015	KJ/RF	of the	- 4
						

